

# Work Order ID 70320

Thursday, June 02, 2011 2:46:11 PM

Page 1

Item ID: D3204-5

Accept

Revision ID:

Item Name: Arm

Start Date: 6/8/2011 Start Qty: 6.00

Required Date: 6/17/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

QC:

Date:

SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop


Run Start


Stop


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
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Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3204	Rev A1

100		0.00
	BAND SAW	
Bandsaw	Memo	0.00
Jeaspa Bandsaw	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)	

110		0.00
	HAAS CNC VERTICAL MACHINING #1	
HAAS 1	Memo	0.00
HAAS CNC vertical machine #1	1- Machine as per Folio FA344 and Dwg D32041 I2- Deburr: Identify as D3204-5	

120		0.00
	QC2- Inspect parts off machine FAI/FAIB	
QC	Memo	0.00
Quality Control		

*Sub 11/06/09*

6 8

*Sub 11/06/09*

6 8

*Sub 11/06/09*

6 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Required Date: 6/17/2011 Req'd Qty: 6.00

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

LA 11/06/09

6 0

11/6/13

MF  
11-06-10

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 02, 2011 2:46:08 PM

Work Order ID: 70320

Parent Item: D3204-5

Parent Item Name: Arm



Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: 11C105.08.111 Added Step 251 KJ/JLM11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.25 0		Purchased	No			100	f	22.0000	0.2913	1.839789			



6061-T6 Bar .375 x 1.25



Location

MAT002

110167

110908

Loc Qty

22

10

12

Loc Code

1.8398 *cmf 11/06/09*

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	1050
Description: Arm		Part Number:	D3204-5
Inspection Dwg: D3204	Rev: A1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	

W/O:		WORK ORDER CHANGES						
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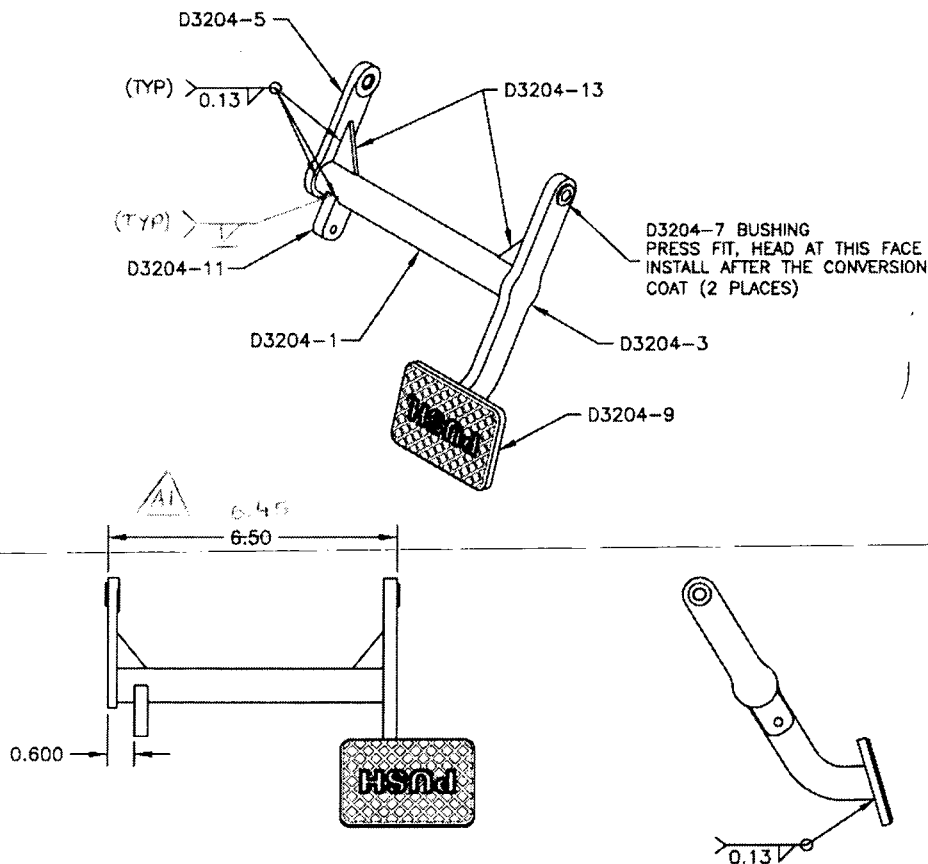
**NOTE:** Date & initial all entries





DESIGN 4	DRAWN BY TH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED  
040430



**D3204-041 RELEASE PEDAL ASSEMBLY**

**NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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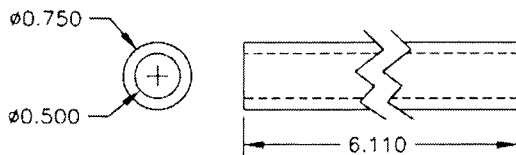
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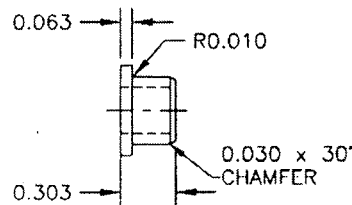


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

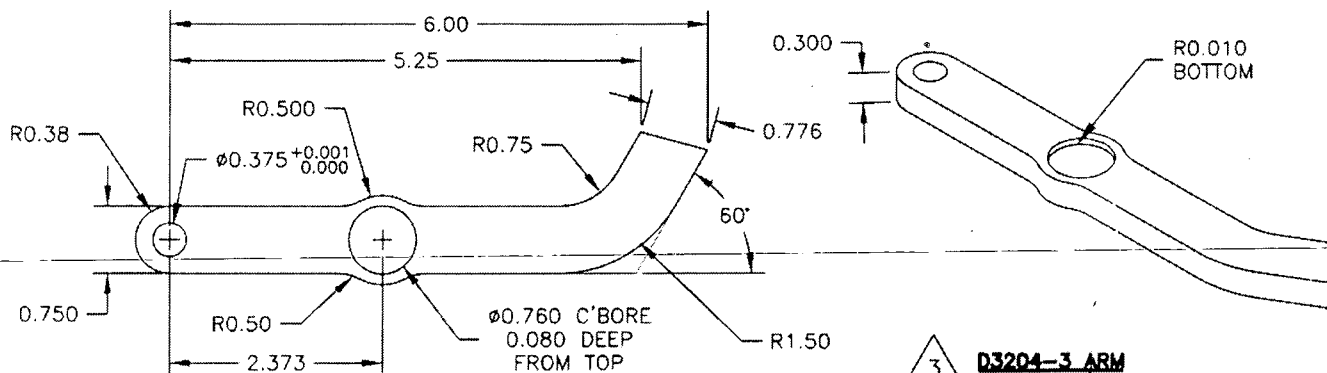
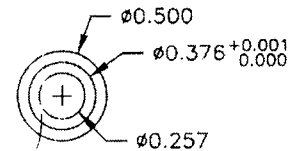
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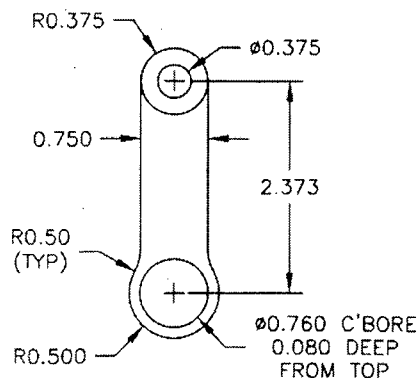
2 D3204-1 TUBE  
SCALE 1:2



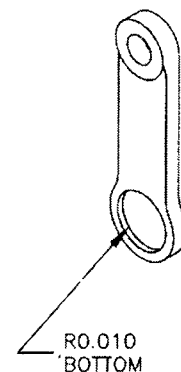
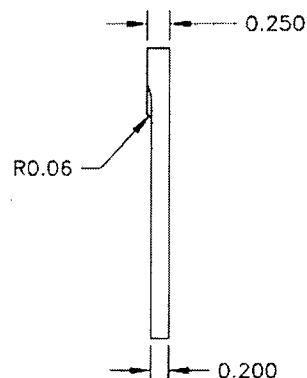
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



70320

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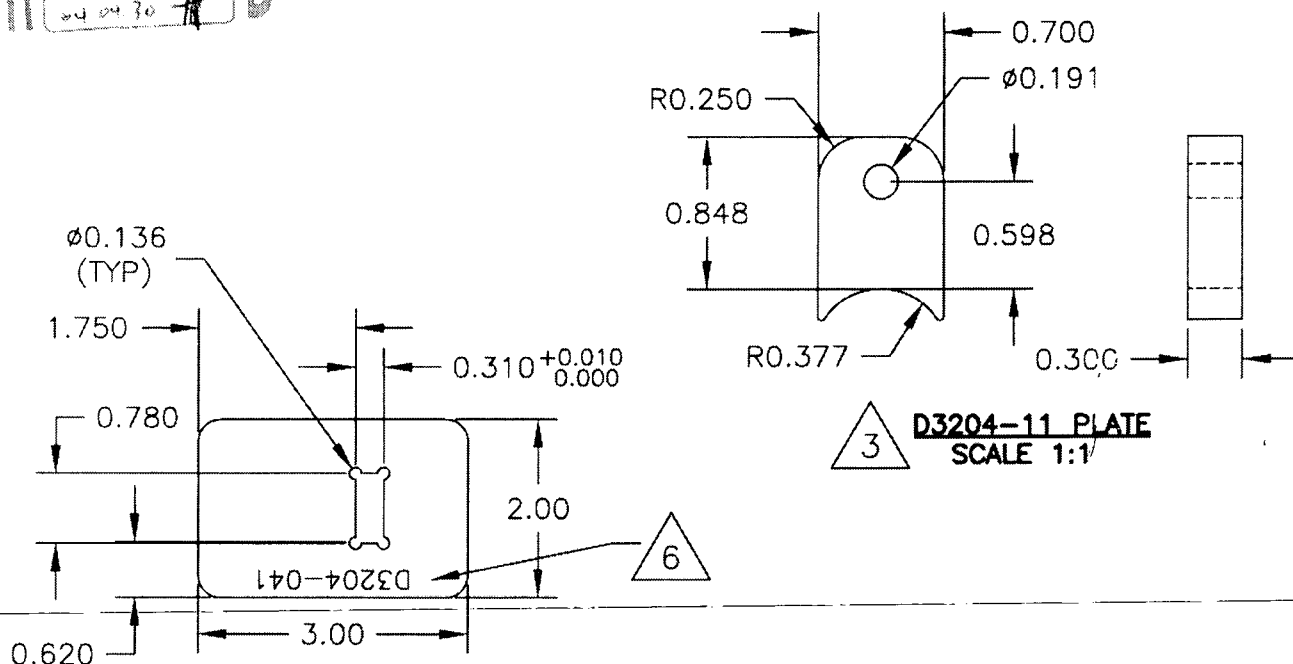
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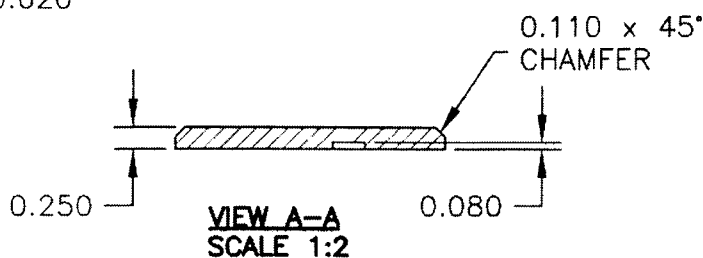


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

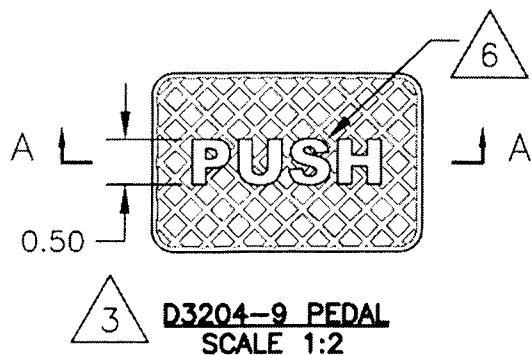
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04 04 30



**D3204-11 PLATE**  
SCALE 1:1



**VIEW A-A**  
SCALE 1:2



**D3204-13 GUSSET**  
SCALE 1:1

20320

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